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54 **Masking tape.**

57 Novel methods for preparing masking tapes by coating a thin layer of polyolefinic material onto a lightweight nonwoven cloth and then applying a thin layer of adhesive, preferably a hot melt adhesive onto the opposed surface of the nonwoven cloth; and novel masking tapes prepared thereby.

In the preferred embodiments, the polyolefinic layer consists essentially of a thin stratum of a high density polyethylene and a thin layer of low density polyethylene.

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## MASKING TAPE

The present invention relates to finger-tearable adhesive tapes of the class known in the art of masking tapes.

While the patent literature is replete with references to masking tapes, those commercially available today employ a crepe paper base or backing for the pressure-sensitive adhesive layer. This paper base is first saturated with a latex binder and then dried. A release coating may then typically be applied to one side of this paper base and a pressure-sensitive adhesive to the other.

The saturation step with the latex binder to improve cohesive strength of the paper and the application of the release coating to provide ease of unwind of the tape both require energy for solvent removal.

A primary object of this invention is to provide a more cost-effective method for manufacturing masking tapes.

Another object is to provide masking tapes having improved elongation and conformability.

In accordance with the present invention, the aforementioned objectives are accomplished by utilising only solid coatings in the masking tapes.

Specifically, the novel masking tapes of this invention are prepared by coating a thin layer of a polyolefinic material onto a light weight nonwoven cloth and then applying a thin layer of pressure-sensitive adhesive, preferably a hot melt adhesive, onto the nonwoven cloth.

In the preferred embodiment, the polyolefinic layer consists essentially of a thin stratum of low density polyethylene and the strata are formed by coextrusion.

As was previously mentioned, the novel masking tapes of this invention comprise: (1) a polyolefinic backing layer; (2) a light weight nonwoven, preferably of the type known as chemically bonded; and (3) a layer of a pressure-sensitive adhesive.

It will of course be appreciated that the nonwoven is not present as a discrete layer. Rather, the coated polyolefinic backing layer will both coat the surface of the cloth and invade its interstices, so that the cloth may be said to be "embedded" in the backing layer as well as being mechanically bonded or laminated thereto.

The polyolefin backing layer of the masking tape can be described as being multi-functional in the sense that it acts as a sealant to the discontinuous nonwoven surface; serves as a barrier layer against adhesive migration; provides ease of unwind from a roll of tape, thereby eliminating the need for a release agent treatment; and, additionally, acts as a reinforcement to the nonwoven cloth which is characterised as possessing poor crossdirectional tear characteristics and tensile strength.

The coated cloth, which may be considered as the backing for the adhesive layer, provides excellent "finger-tearability", i.e. cross-tear properties, as well as elongation and improved tensile strength. The nonwoven, with its apertured discontinuous surface, in turn provides improved anchorage of the adhesive to the film backing in the resulting laminate, in view of the fact that a portion of the adhesive layer is anchored to the polyolefin backing layer.

In theory, any of the polyolefinic materials heretofore employed in the art as backing layers for adhesive tapes may be employed in the practice of this invention. As examples of such materials, mention may be made of the polyethylenes, e.g. low density (LDPE), high density (HDPE), very low or ultra low density (VLDPE), and linear low density (LLDPE) polyethylene. Other useful polyolefins which may be used alone or in combination, e.g. with polyethylene, include ethylene vinyl acetate copolymers, ethylene propylene rubber, EPDM, polypropylene, polyvinyl chloride, polyisobutylene, and conjugated diene butyl polymers.

As previously mentioned, in the preferred embodiment of this invention, the backing layer is what may be termed a two-layer backing consisting essentially of an outer layer of one polymer e.g. HDPE and an inner layer of another polymer e.g. LDPE. In this preferred embodiment, the two-layer backing may be formed by coextrusion coating it onto the nonwoven cloth. In any event, the combined thickness of the two layers will be no greater than 3.0 mils (0.075 mms) but more than 2.5 mils (0.0635 mms). The ratio of thickness of the HDPE and LDPE in this two-layer backing will be of the order of from 8:1 to 1:8 e.g. from less than 7:8 to 1:8. While the aforementioned two-layer backing is the preferred form of the invention, it will be appreciated that where found desirable or expedient to do so, a tie coat may be employed between the backing layer(s) and the nonwoven.

The particular HDPE and/or LDPE to be employed may be any of those known in the art. By way of illustration, excellent results are obtained utilising HDPE and LDPE commercially available from Chevron Chemical under the trade designations 9116 and 4560, respectively. 9116 high density polyethylene resin has a density of 0.958 gram/cubic centimetre; and 4560 low density polyethylene resin has a density of 0.923 gram/cubic centimetre.

An important aspect of this preferred embodiment of the invention is the improved tensile strength obtainable by employing the two-layer HDPE/LDPE backing layer over LDPE alone. While LDPE is more cost-effective and conformable than HDPE, replacing some of the thickness of the backing layer with HDPE has been found to provide the requisite tensile strength for the contemplated masking tape which is not obtainable by employing LDPE alone.

The double layer may range from a ratio of thickness of the HDPE to the LDPE layers of 1.4 : 1.6 or 1:1.15 to 1:0.5 or more broadly 1:1 to 1:0.5.

The following table illustrates the improved tensile strength obtainable with the HDPE/LDPE two-layer backing over LDPE alone.

TABLE 1

£	Resin	Density	Melt Index	Thickness	Tensile Strength	Elongation
		(g/cm <sup>3</sup> )	(g/10 min)	(mils)	(lb/in)	(%)
1	LDPE	.923	3.5	2.0	10	8
2	LDPE	.917	12.0	1.5	9	8
3	LDPE	.923	10.0	1.5	9	8
4	LDPE	.923	10.0	2.0	11	9
5	HDPE/LDPE	.958/.923	30/10	1.4/1.6	14	13
6	HDPE/LDPE	.958/.923	30/10	1.0/0.5	12	13
7	HDPE/LDPE	.958/.923	30/10	.75/.75	11	9

\* resin to nonwoven cloth

The nonwoven cloth to be employed will preferably be any of the synthetic nonwovens heretofore known in the art. As mentioned above it is a light weight cloth e.g. weighing less than 50 grams per square yard (grams/sq. metre). Suitable synthetic fibres include the rayons, polyesters, polyamides, acrylics, etc. As is known, the fibres may first be carded to orient them primarily in the machine direction. The carded fibres may then be subjected to scrambling, after which they may be chemically or thermally bonded, or hydroentangled to produce the nonwoven fabric, all in per se known manner in the art.

Preferably, however, the nonwoven will be chemically bonded, i.e. the fibre web will be contracted with one or more of the known bonding agents in known manner such as by impregnation, printing, etc. Useful binders for this purpose include acrylics, vinyl acrylics, acetate/ethylene, polyvinyl acetate, polyesters, etc.

The adhesives employed to prepare the masking tapes of this invention may be any of those heretofore employed in the art for preparing masking tapes, the selection of which per se comprises no part of this invention. Preferred are those known in the art as "hotmelt" adhesives, which adhesives are characterised as being non-volatile adhesives made of synthetic resins and plasticisers and applied to the backing hot in the molten state. As those skilled in the art will appreciate, the adhesive should be sufficiently aggressive to adhere well to the contemplated substrates, e.g. glass, metal, plastic, etc., but should also be characterised as having good unwind from the adhesive tape roll and no discernible adhesion stick after removal.

By way of illustration, suitable adhesives of this general description include rubbery block copolymers containing a polyisoprene midblock such as are disclosed in U.S.P. 4,699,941 or the hotmelt adhesives disclosed, for example, in U.S. Patent Nos. 4,623,698; 4,636,555; 4,669,163; 4,698,242; 4,698,405 or 4,717,749.

In any event, the selected adhesive will be applied in a layer not thicker than 2.0 mils (0.05 mms) but preferably more than 1.5 mils (0.038 mms) thick.

The manner of applying the adhesive to the nonwoven cloth also is not critical to the practice of this invention. Preferably, it is applied by using a hot melt applicator. However, other modes of application such as solvent coating, extrusion coating, and the like may also be employed.

As was previously mentioned, in the preferred embodiment, the backing layer is polyolefinic and preferably consists essentially of a two-layer backing, namely a thin HDPE and a thin LDPE stratum. While not critical to the practice of this invention how the two strata are applied, a particularly efficacious way of doing so is by coextrusion utilising per se known coextrusion techniques.

In general, such known coextrusion techniques employ two or more extruders, each delivering a single

component polymer melt (in this case HDPE/LDPE) to a combining feedblock which streamlines, combines and feeds the polymers to a single- or multimanifold coathanger die which in turn feeds the two-layered film into a roll/nip where the cloth web is fed simultaneously at that point to form the backing layer/nonwoven laminate. Standard single screw extruders may be employed to melt and pump the individual layers into the coextrusion feedblock or die, as the case may be. High extrusion temperature profiles, e.g. 500-600 °F, (260 - 316 °C) are advisable in this stage as well as in the feedblock and die stages. These high temperatures will improve the bonding mechanism of the coextruded layers to the cloth.

Preferably, the feed pipes connecting the extruders to the feedblock should be kept to the shortest length possible to avoid long residence time which may result in polymer degradation as well as high pressure drop that could cause melt surges.

The die employed in the extrusion coating applications typically consist of a single- or multimanifold coat hanger design with a tear drop cross section and narrow land length. This design facilitates better control over the thin film thicknesses through gradual and continuous build up of head pressure.

Since the coextrusion techniques, as described briefly above, are well known in the art, such details as barrel and die temperatures, screwspeeds and the like will be well understood and a further detailed description is not necessary for a clear understanding of the invention.

The following examples show by way of illustration and not by way of limitation the practice of this invention.

### Example 1

A mixture of 95% LDPE and 5% of a 50/50 blend of a colour pigment and LDPE (total contents: 97.5% by weight LDPE and 2.5% by weight pigment); and a mixture of 95% HDPE and 5% of a 50/50 blend of colour pigment and HDPE (total contents: 97.5% HDPE and 2.5% pigment) were coextruded onto a rayon/polyester blend nonwoven cloth weighing 17 grams per square yard (14.2 grams/m<sup>2</sup>) to provide a two-layer backing wherein the outer layer was a 1.3 mil (0.033 mms) thick HDPE layer and the inner layer bonded to the cloth was a 0.7 mil (0.018 mms) LDPE layer. The processing conditions for the extrusion coating was as follows:

	Extruder 1	Extruder 2
Temp., barrel zone 1	350 °F 177 °C	350 °F 177 °C
Temp., barrel zone 2	450 °F 232 °C	450 °F 232 °C
Temp., barrel zone 3, 4, 5	550 °F 288 °C	550 °F 288 °C
Temp., Adapter	550 °F 288 °C	550 °F 288 °C
Temp., Die zones 1-5	550 °F 288 °C	550 °F 288 °C
Melt temp.	550 °F 288 °C	550 °F 288 °C
RPM	87	51
Head Pressure (psi)	1100	1200
Output (psi)	87	255
Line speed (ft/min)	225	-
Nip roll pressure (psi)	40	-

A styrene/isoprene block copolymer hot melt pressure sensitive adhesive (pale yellow colour; softening point (Ring & Ball), 223-233 °F (106-112 °C) application temperature, 300-330 °F (149-166 °C); specific gravity, 0.93-0.97; solids content, 100%) was then applied to the opposed surface of the cloth by slot die coating using a hot melt applicator at a temperature of about 300 °F (149 °C) to provide an adhesive coating weighing about 20 grams per square yard (grams/m<sup>2</sup>), the coating being about one mil (0.0259 mms) thick.

### EXAMPLE 2

Example 1 was repeated, except that the adhesive coating was applied at a thickness calculated to be 0.8 mil (0.020 mms).

EXAMPLE 3

Example 1 was repeated again, except that the adhesive coating was applied at a thickness calculated to be 0.7 mil (0.018 mms).

The masking tape prepared in the foregoing manner, may then be slit into desired widths, e.g. one, two or three inch (2.5, 5 or 7.5 cm) widths.

The tapes prepared in the foregoing examples were compared for adhesion, probe, unwind and elongation at 25° C with six commercially available standard brand masking tapes (designated in the following table simply as Control 1 through Control 6, respectively).

The data for these comparative tests is set forth in Table 2. Since the data will vary slightly in repeat tests, for the sake of greater accuracy the numbers recited are averages for several tests.

TABLE 2

Test Sample	Adhesion/Steel	Adhesion/back	Probe	Unwind	Elong.
	(oz/in)	(oz/in)	(100g)	12"/min	
Example 1	43	32	311	28	13
Example 2	33	28	198	21	13
Example 3	23	19	176	13	13
Control 1	35	21	233	21	4
Control 2	61	22	327		6
Control 3	24	11	90		7
Control 4	47	25	342		8
Control 5	36	14	145		11
Control 6	33	18	183		10

As will be seen from the data on the Controls (commercial masking tape) in the foregoing table, there is a fairly wide range on the adhesion to steel and adhesion to backing, as well as the probe, thus indicating that there appears to be no defined criteria for consumer acceptance of these physical qualities. In any event, it is clear that the novel tapes of this invention compare favourably in these aspects. Of particular interest is the markedly superior elongation of the tapes of this invention, thus confirming that this task of the invention has been solved.

Because of this increased elongation, the masking tapes of this invention have markedly improved ability to wrap around objects and strict conformance to the substrate shape. Such properties render the tapes particularly advantageous for such common usages as masking prior to painting. With respect to painting by auto body shops and the like, it has been observed that the novel tapes of this invention provide cleaner lines of paint, an important advantage of this invention.

Since certain changes may be made without departing from the scope of the invention herein involved, it is intended that all matter described in the foregoing description, including the examples, shall be interpreted as illustrative and not in a limiting sense.

**Claims**

1. A masking tape characterized in that it comprises, in order, a polyolefinic backing layer no thicker than 3.0 mils (0.075 mms) but more than 2.5 mils (0.0635 mms) thick; a nonwoven cloth; and a layer of pressure-sensitive adhesive no thicker than 2.0 mils (0.05 mms).
2. A masking tape as claimed in Claim 1 in which the adhesive layer is more than 1.5 mils (0.038 mms) thick.
3. A masking tape as claimed in Claim 1 or Claim 2 in which the said adhesive is a hot melt adhesive.
4. A masking tape as claimed in Claim 1, 2 or 3 in which the said backing material comprises an outer stratum of high density polyethylene and an inner stratum of low density polyethylene.
5. A masking tape as claimed in Claim 4 in which the ratio of thickness of the said high density

polyethylene stratum to the said low density polyethylene stratum is from 8:1 to 1:8.

6. A masking tape as claimed in Claim 8 in which the ratio is from less than 7:8 to 1:8.

7. A masking tape as claimed in any one of claims 1 to 6 in which the nonwoven cloth is a rayon/polyester blend.

5 8. A masking tape as claimed in any one of claims 1 to 7 in which the said nonwoven cloth is chemically bonded.

9. A masking tape as claimed in any one of Claims 1 to 8 in which the said cloth possesses discontinuous surfaces with interstices between its fibres and the said polymeric backing material both coats one surface of the said cloth and invades its interstices.

10 10. A method of making an adhesive tape comprising the steps of coextruding a thin layer of high density polyethylene and a thin layer of low density polyethylene onto one surface of a nonwoven cloth, the said cloth being characterised as being embedded in said low density polyethylene; and thereafter applying a thin layer of a pressure-sensitive adhesive onto the opposed surface of said cloth, a portion of the said adhesive being bonded to the said low density polyethylene, the said coextruded layers having a combined  
15 thickness no greater than 3.0 mils (0.075 mms) but more than 2.5 mils (0.0635 mms).

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54 **Masking tape.**

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## EUROPEAN SEARCH REPORT

Application Number

EP 90 30 8055

### DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)
P,X	EP-A-0 336 727 (THE KENDALL COMPANY) * claims *	1-10	C 09 J 7/02
X	FR-A-2 398 603 (STAUFFER CHEMICAL) * claims 1,6,11 * * page 4, line 2 - line 10 * * page 5, line 18 - line 25 *	1,2,7	
A	GB-A-1 230 097 (EVOMASTICS LD.)		
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
			C 09 J
The present search report has been drawn up for all claims			
Place of search		Date of completion of search	Examiner
The Hague		21 February 92	GIRARD Y.A.
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone			
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